

Work Order ID 98233

March-11-13 11:00:04 AM

98233

Page 1

Item ID: D4634-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/25/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: HLJ Date: 13-03-11 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4634

REV B. JLN

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

B 13/03/13

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4634-141

1- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # 124600

Expiry Date 13/10/16

2- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

B 13/04/08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Item ID: D4634-141

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/25/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: Date: Tooling: Date:

Stop ***NR2***

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130 Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

140 QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
16
2.22 13/04/09

MED TAP B95734

DL
13/04/10

13/4/11

13-04-11

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:08 AM

Page 1

Work Order ID: 98233

98233

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/02/05 DL VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4634-1		Manufactured	No			100	Each	0.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4634-1

Fwd, Center Ceiling Panel

D4647-3		Manufactured	No			100	Each	15.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4647-3

Angle

Location

Loc Qty

Loc Code

ST117

15

92970

15

D4664-5		Manufactured	No			100	Each	70.0000	6	6			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4664-5

Spacer

Location

Loc Qty

Loc Code

ST117

40

93071

40

ST119

30

95931

30

D4694-041		Manufactured	No			100	Each	2.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4694-041

Fwd Channel Assembly

Location

Loc Qty

Loc Code

ST158

2

93076

1

95941

1

D4712-041		Manufactured	No			100	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4712-041

Bracket Assembly

93105

D4634-1

07

13/04/09

D4647-3

07

13/04/09

D4664-5

07

13/04/09

D4694-041

07

13/04/09

D4712-041

07

13/04/09

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
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		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:08 AM

Page 2

Work Order ID: 98233

98233

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

D4732-15 Manufactured No

D4732-15 ✓

Label

100 Each 9.0000 1 1

** 1

D4634-141
07-89
13/04/09

Location

Loc Qty

Loc Code

ST120

9

93220

9

D4732-19 Manufactured No

D4732-19 ✓

Label

100 Each 9.0000 1 1

** 1

D4634-141
07-89
13/04/09

Location

Loc Qty

Loc Code

ST120

9

93356

9

MPNY-750S-9-C Purchased No

MPNY-750S-9-C

Mounting Pad

100 Each 100.0000 8 8

** 8

D4634-141
07-89
13/04/09

Location

Loc Qty

Loc Code

ST390

100

124058

100

MS20426AD3-3 Purchased No

MS20426AD3-3 ✓

Rivet

100 Each 7.041.000 4 4

** 4

D4634-141
07-89
13/04/09

Location

Loc Qty

Loc Code

GA

65

122814

65

ST316

699

119109

282

19099

417

ST333

6277

121011

69

123352

6208

March-11-13 11:00:08 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

March-11-13 11:00:08 AM

Page 3

Work Order ID: 98233

98233

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd. Center Ceiling Replacement Panel Assembly

Start Date: 3/11/13

Required Date: 3/25/13

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

100

Each

299.0000

2

2

MS21059L3

2

Nut Plate

D4634-141
07
13/07/09

Location

Loc Qty

Loc Code

ST316

99

124291

99

ST506

200

124308

200

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

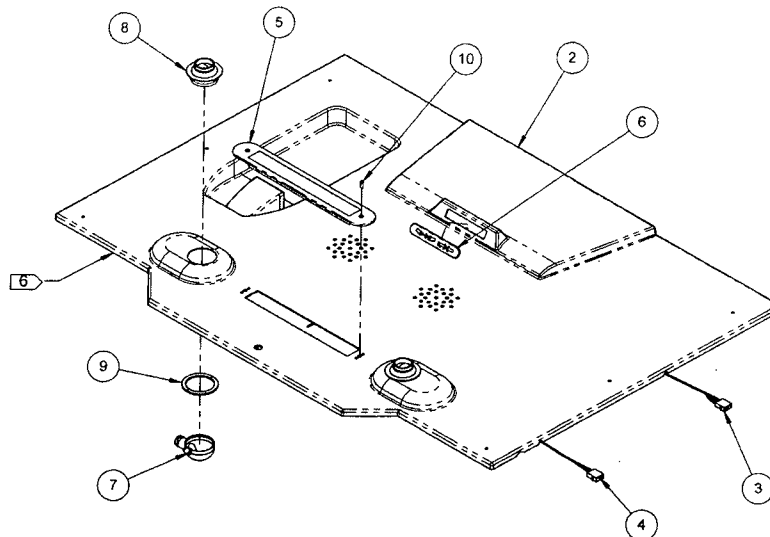
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



D4634-041 FWD, CENTER CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE*
- 7) WEIGHT: 7.5 lbs
- 8) INSTALL D4728-047-051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
4	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

SH 4 1 1 1
 R 1 1 1 1
 ENGINE 1 1
 UNCONTROL 1 1
 SUBJECT TO 1 1
 WITH 1 1 1 1
 WORK 1 1 1 1
 NO 98233 ML5
 13-03-11

RELEASED
 2013-01-30

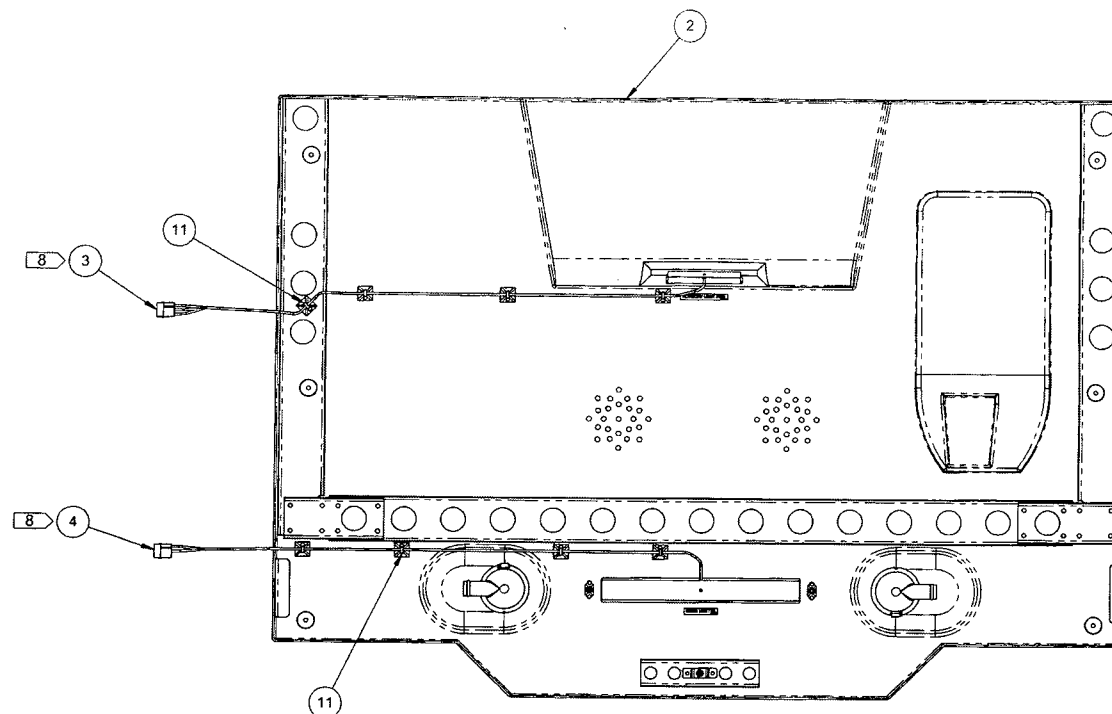
B	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9); REVISE D4634-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADD DETAILS R,S,T SHT 10, 12, 14, 16, 17	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.11.30		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D4634 SHEET 1 OF 17
 TITLE SCALE
CENTER CEILING PANELS NTS

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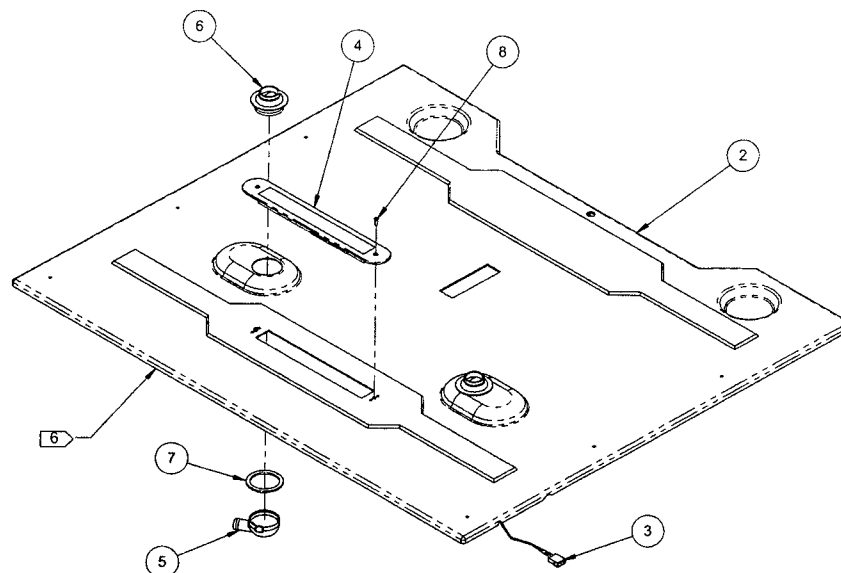
D4634-041 FWD. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

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2013-01-30

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 2 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
4	1	D4638-1	LED LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4652-1	AIR VALVE
7	2	D4652-3	MOUNTING NUT
8	2	MS24694-S5	SCREW
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

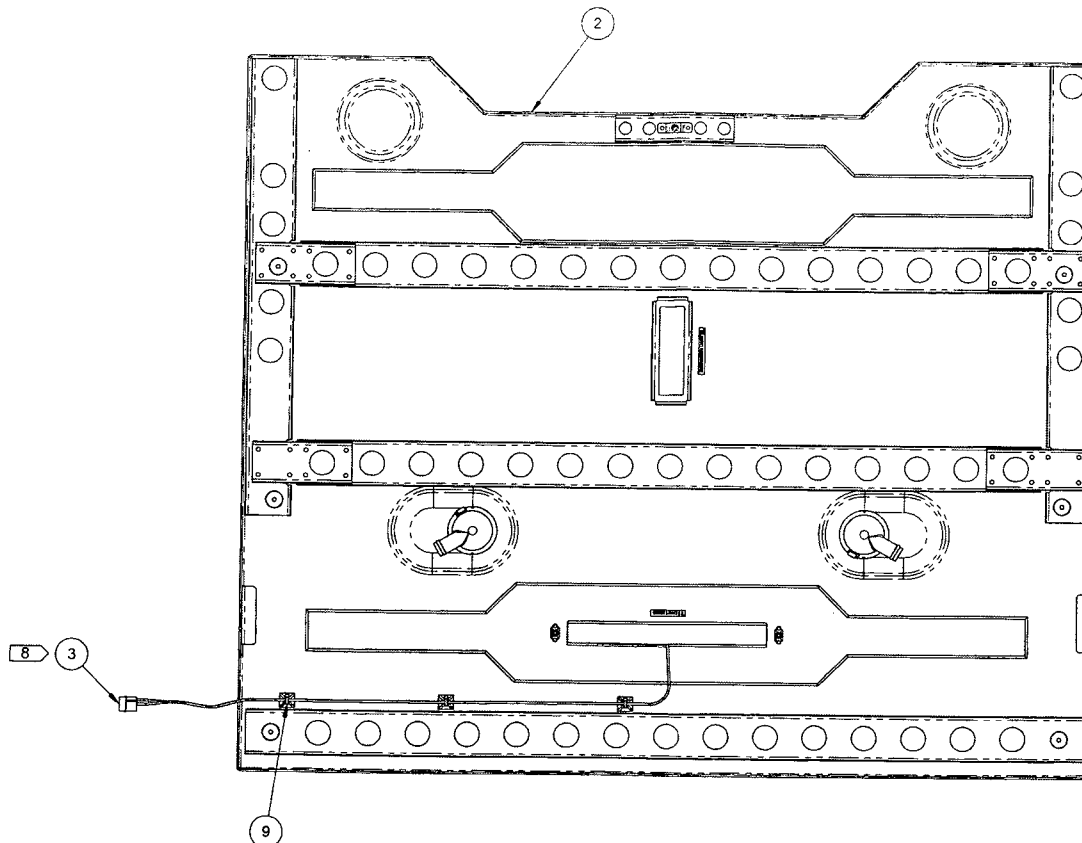
**D4634-043 MIDDLE, CENTER CEILING PANEL ASSY****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

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2013-01-30

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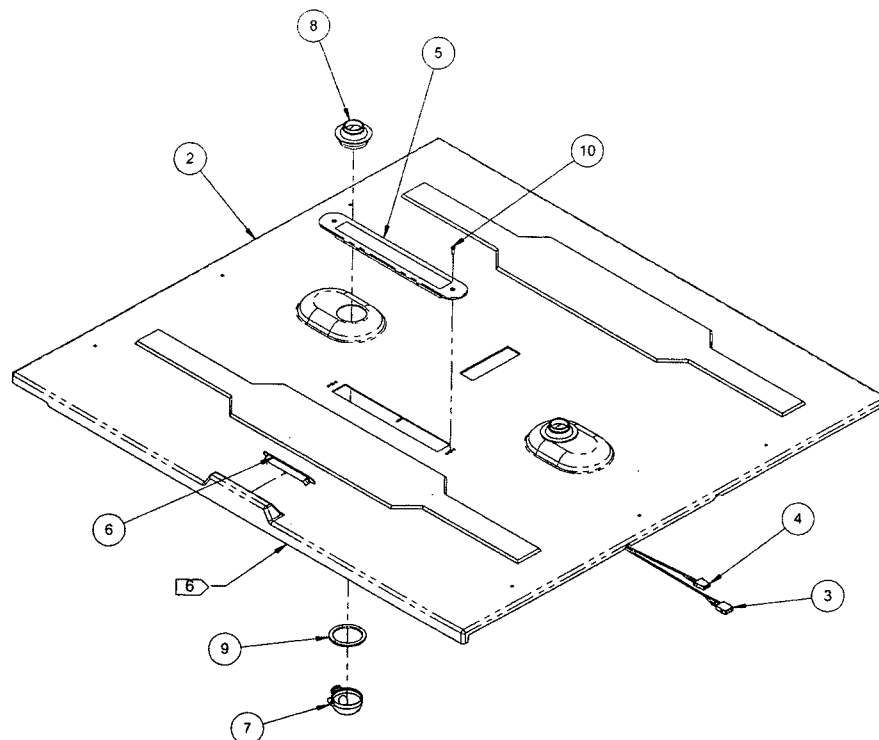


D4634-043 MIDDLE, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

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2013-01-30
AM

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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 4 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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**D4634-045 AFT. CENTER CEILING PANEL ASSY****NOTES:**

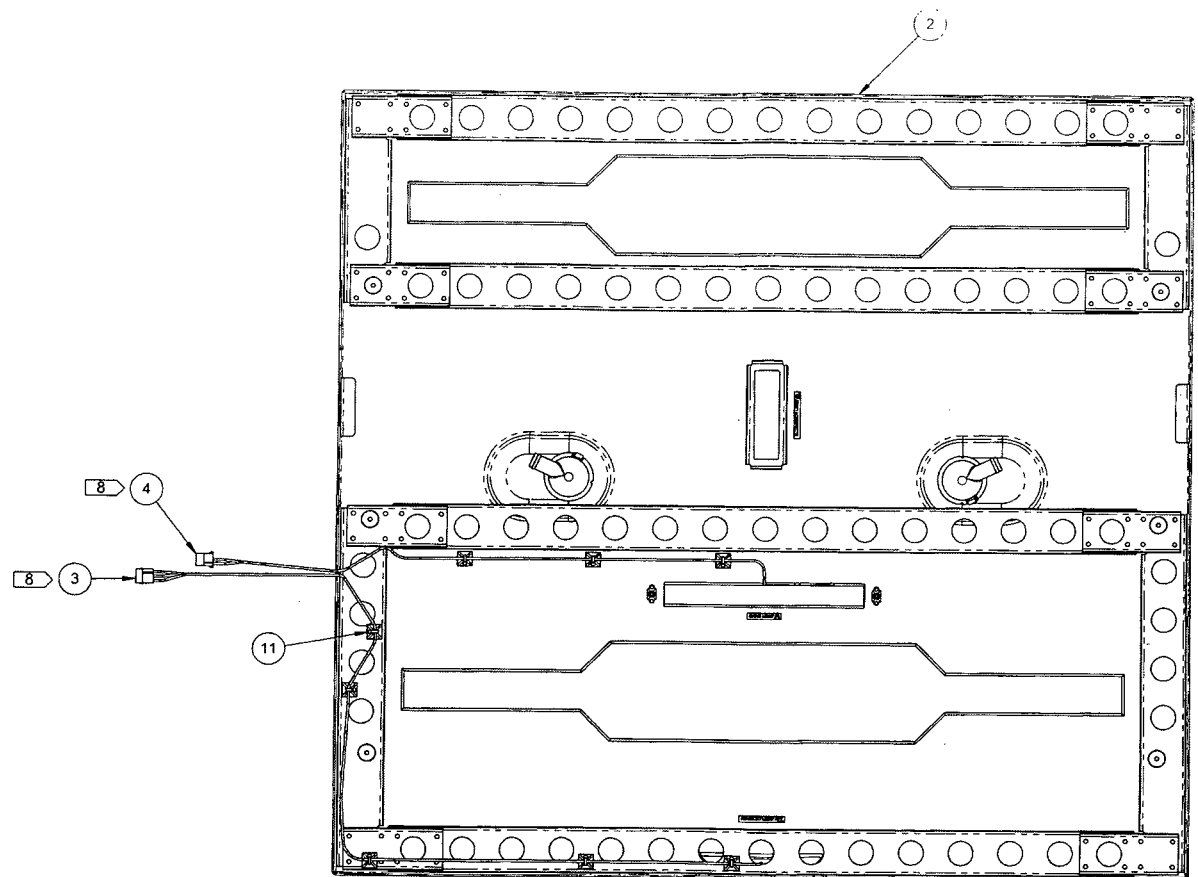
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.0 lbs
- 8) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT. CENTER CEILING PANEL ASSY
2	1	D4634-145	AFT. CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
4	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

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MFG. APPR.	RF	D4634	SHEET 5 OF 17
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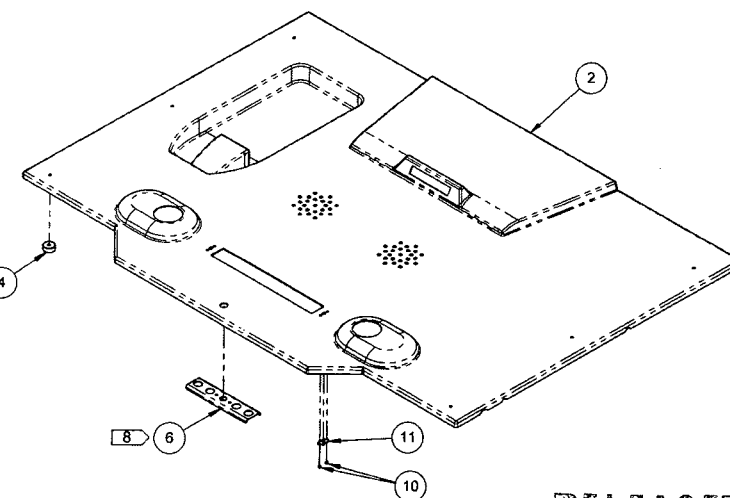
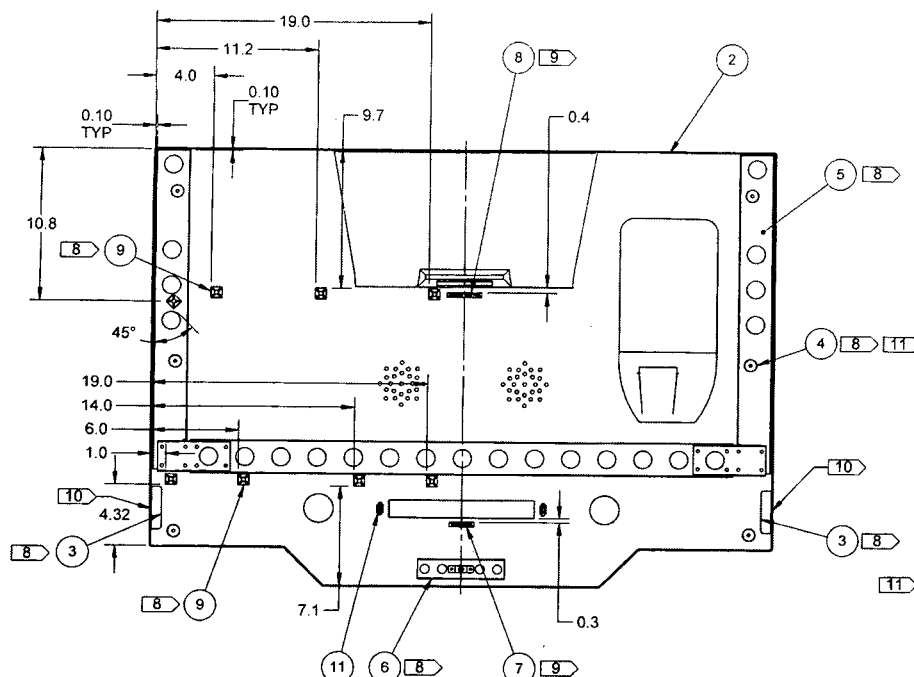
D4634-045 AFT, CENTER CEILING PANEL ASSY
AUXILIARY VIEW

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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 6 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4634-141	FWD. CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD. CENTER CEILING PANEL
3	2	D4647-3	ANGLE
4	6	D4664-5	SPACER
5	1	D4694-041	FWD CHANNEL ASSEMBLY
6	1	D4712-041	BRACKET ASSEMBLY
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	8	MPNY-750S-9-C	MOUNTING PAD
10	4	MS20426AD3-3	RIVET
11	2	MS21059L3	ANCHOR NUT



D4634-141 FWD. CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

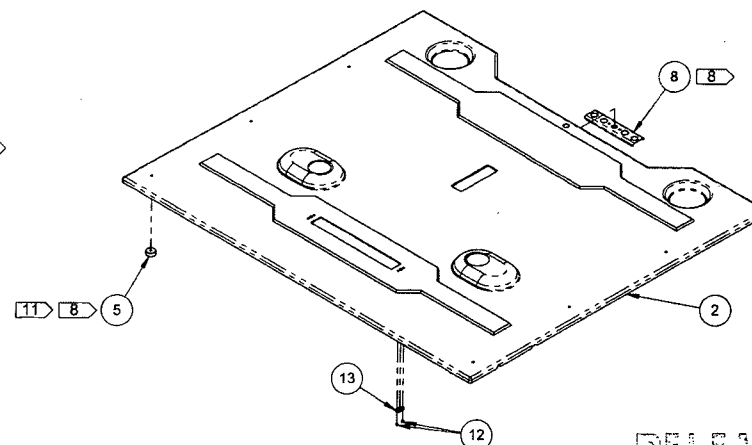
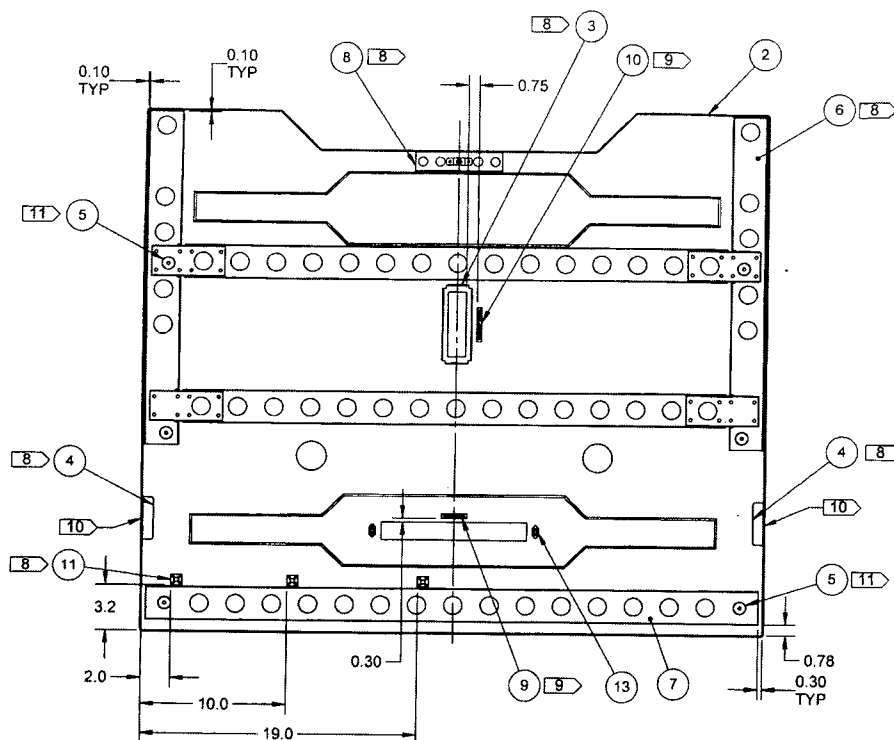
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.3 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-3, D4664-5, D4694-041, D4712-041 & MPNY-750S-9-C. WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH $\phi 0.204$ HOLES
- 9) LOCATE LABELS AS SHOWN. SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-1 FWD CENTER PANEL
- 11) TRANSFER $\phi 0.204$ (#6 DRILL) FROM D4634-1 TO D4694-041 PRIOR TO BONDING D4664-5

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MFG. APPR.		D4634	SHEET 7 OF 17
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	1	D4647-1	DOUBLER
4	2	D4647-3	ANGLE
5	6	D4664-5	SPACER
6	1	D4694-043	MIDDLE CHANNEL ASSEMBLY
7	1	D4694-7	MIDDLE CHANNEL
8	1	D4712-041	BRACKET ASSEMBLY
9	1	D4732-21	LABEL
10	1	D4732-25	LABEL
11	3	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-3	RIVET
13	2	MS21059L3	ANCHOR NUT



D4634-143 MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY

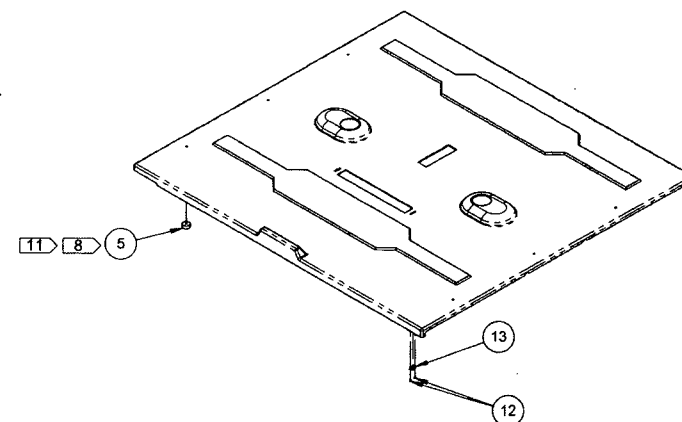
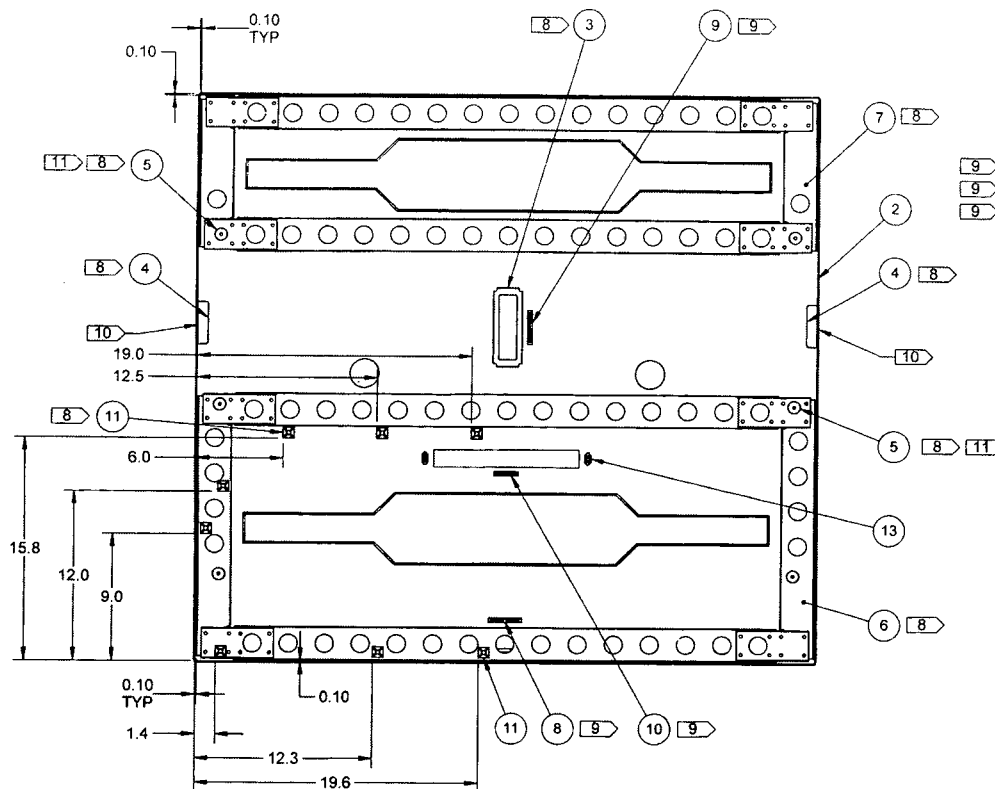
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-1, D4647-3, D4664-5, D4694-043/-7, D4712-041 & MPNY-750S-9C WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH $\phi 0.204$ HOLES. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-3 MIDDLE CENTER PANEL
- 11) TRANSFER $\phi 0.204$ (#6 DRILL) FROM D4634-3 TO D4694-043/-7 PRIOR TO BONDING D4664-5

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	RF	D4634	SHEET 8 OF 17
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DE APPR.	RF	CENTER CEILING PANELS	NTS
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4634-145	AFT. CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT. CENTER CEILING PANEL
3	1	D4647-1	DOUBLER
4	2	D4647-3	ANGLE
5	6	D4664-5	SPACER
6	1	D4694-045	AFT CHANNEL ASSEMBLY
7	1	D4694-047	AFT CHANNEL ASSEMBLY
8	1	D4732-17	LABEL
9	1	D4732-27	LABEL
10	1	D4732-23	LABEL
11	8	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-3	RIVET
13	2	MS21059L3	ANCHOR NUT



D4634-145 AFT. CENTER CEILING REPLACEMENT PANEL ASSY

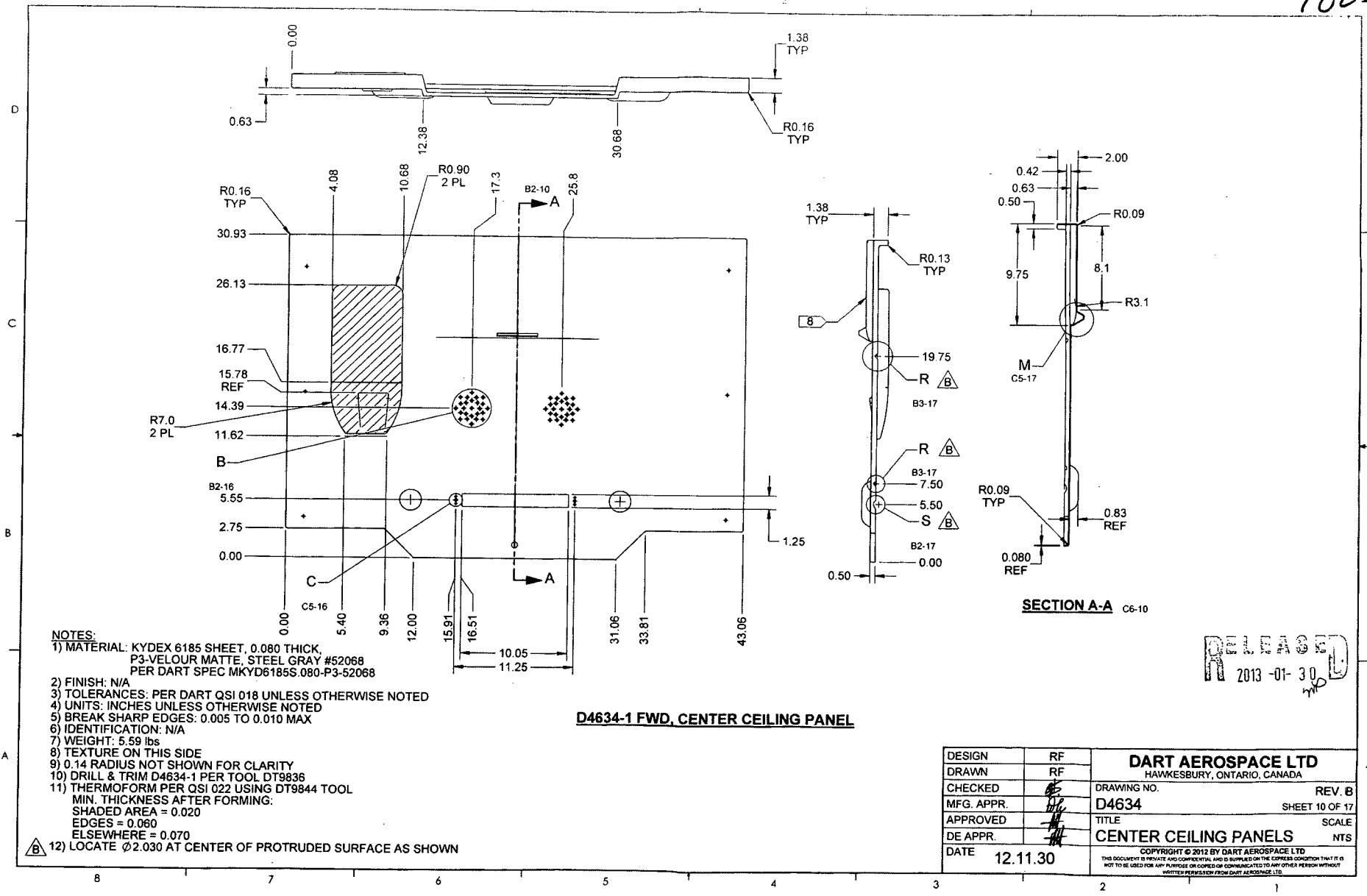
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4647-1, D4647-3, D4664-5, D4694-045/-047 & MPNY-750S-9-C. WAIT FOR 24 HOURS TO CURE. LOCATE D4664-5 IN LINE WITH Ø0.204 HOLES. LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 9) LOCATE LABELS AS SHOWN. SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-5 AFT CENTER PANEL
- 11) TRANSFER Ø0.204 (#6 DRILL) FROM D4634-5 TO D4694-045/-047 PRIOR TO BONDING D4664-5

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MFG. APPR.	RF	D4634	SHEET 9 OF 17
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
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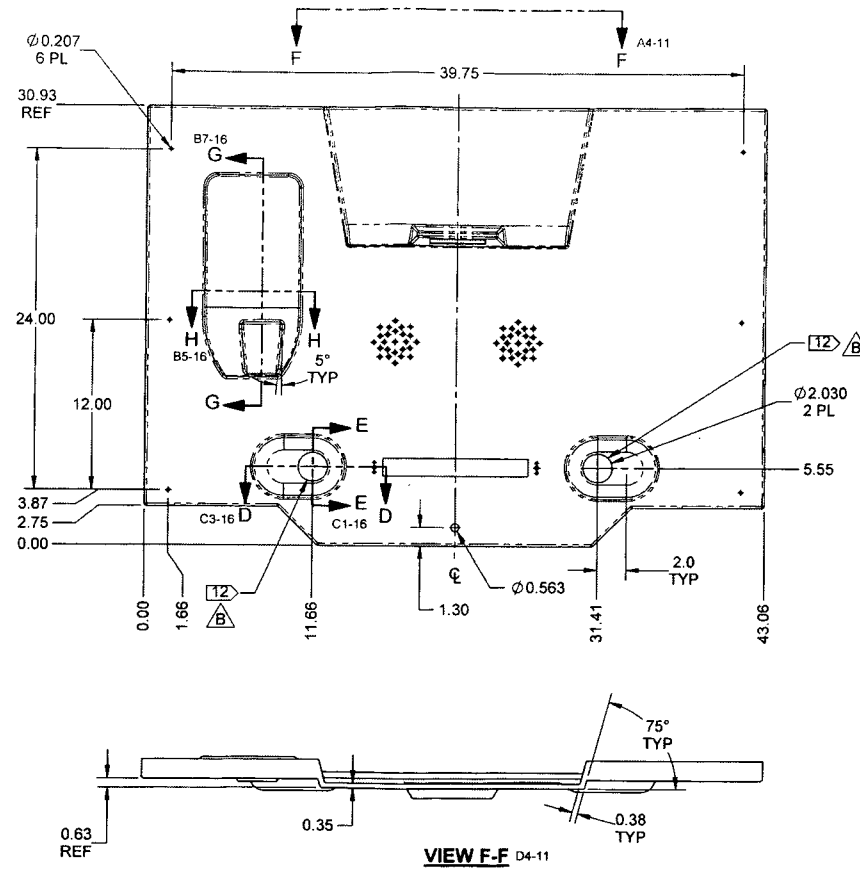


- NOTES:
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 PER DART SPEC MKYD6185S.080-P3-52068
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.59 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
 - 10) DRILL & TRIM D4634-1 PER TOOL DT9836
 - 11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
 - 12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-1 FWD, CENTER CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 10 OF 17
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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98233

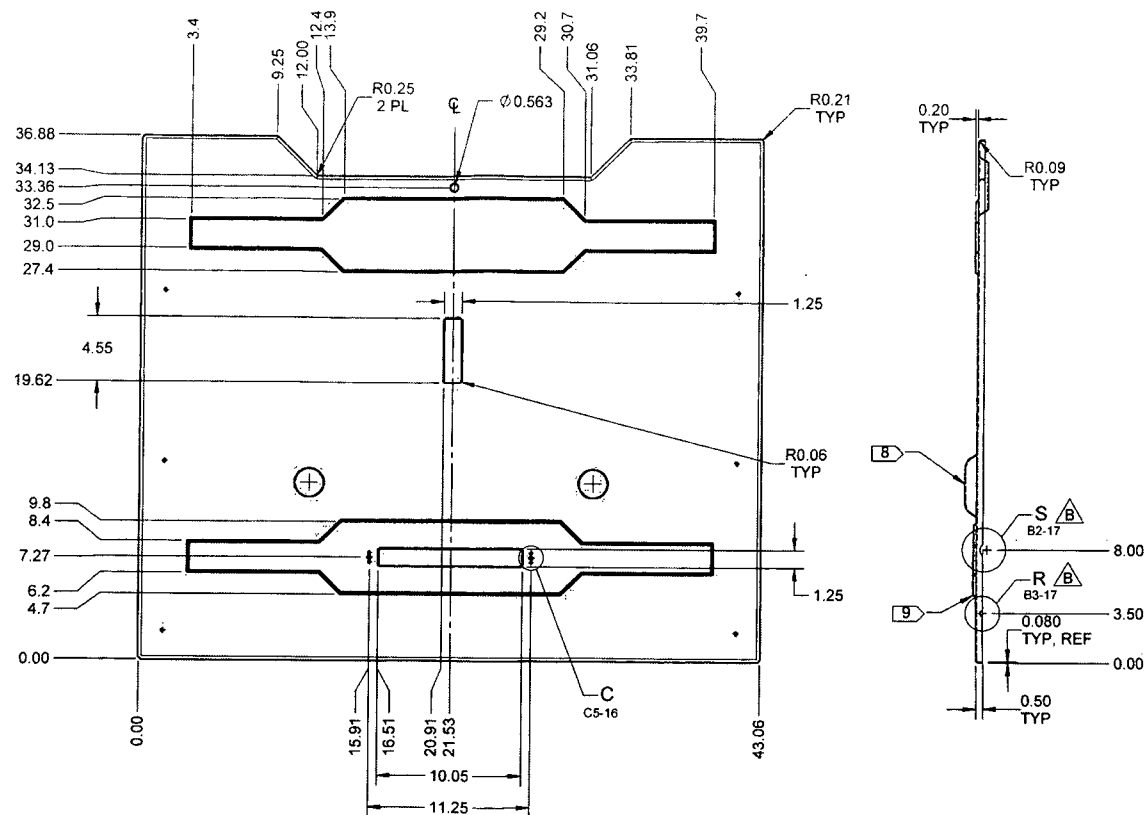


D4634-1 FWD. CENTER CEILING PANEL
AUXILIARY VIEW

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2013-01-30

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 11 OF 17
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NOTES:

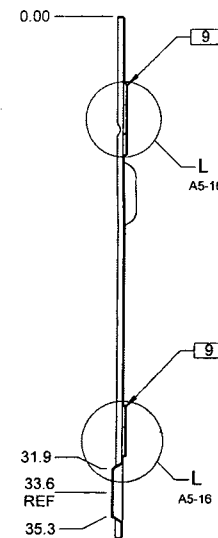
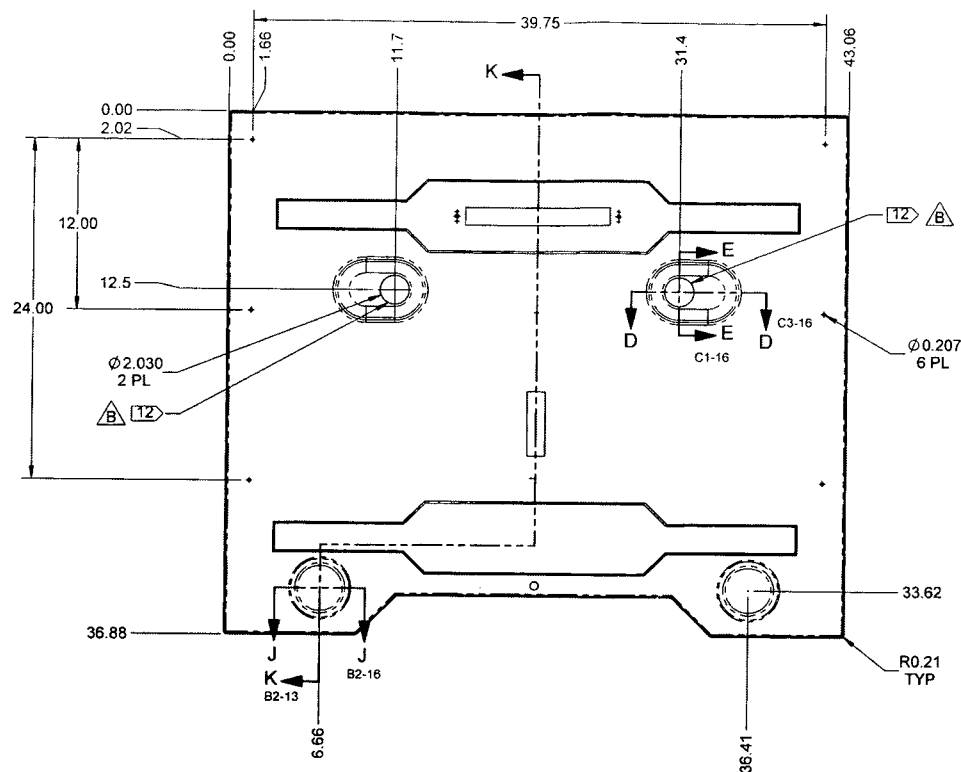
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.31 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-3 PER TOOL DT9837
- 11) THERMOFORM PER QSI 022 USING DT9845 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
- 12) LOCATE $\varnothing 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

RELEASED
2013-01-30

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MFG. APPR.	RF	D4634	SHEET 12 OF 17
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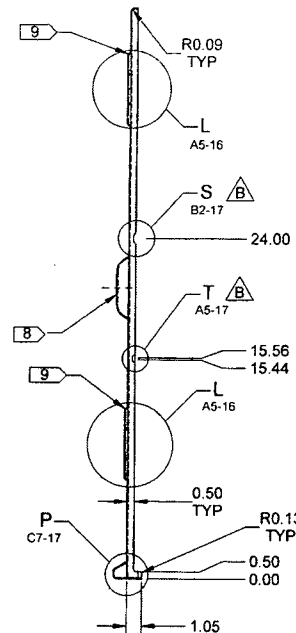
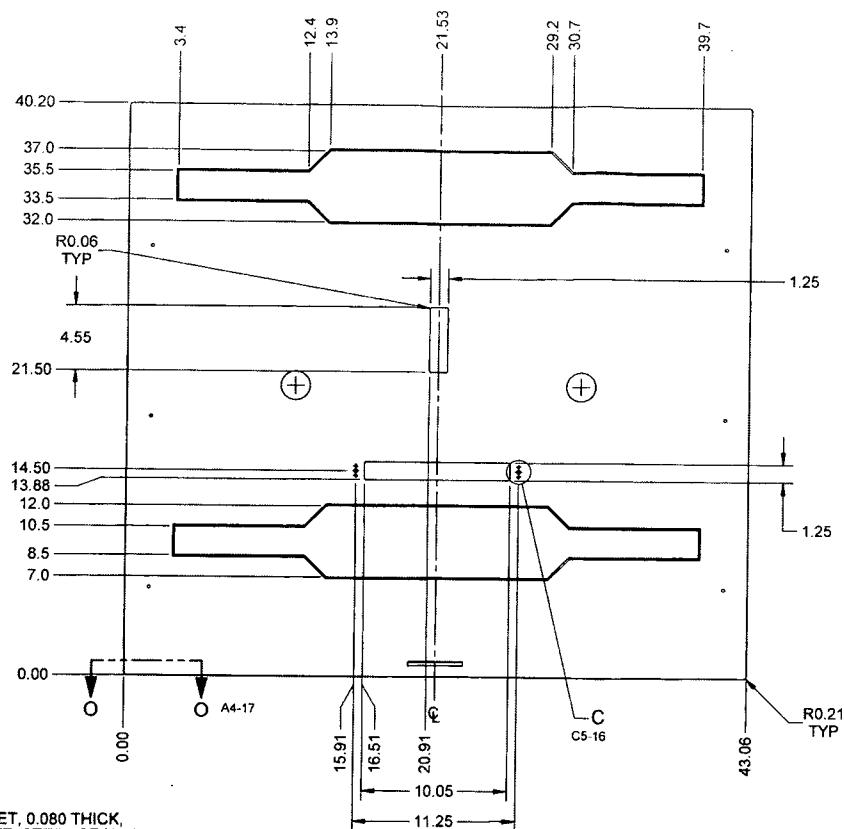
D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

SECTION K-K B6-13

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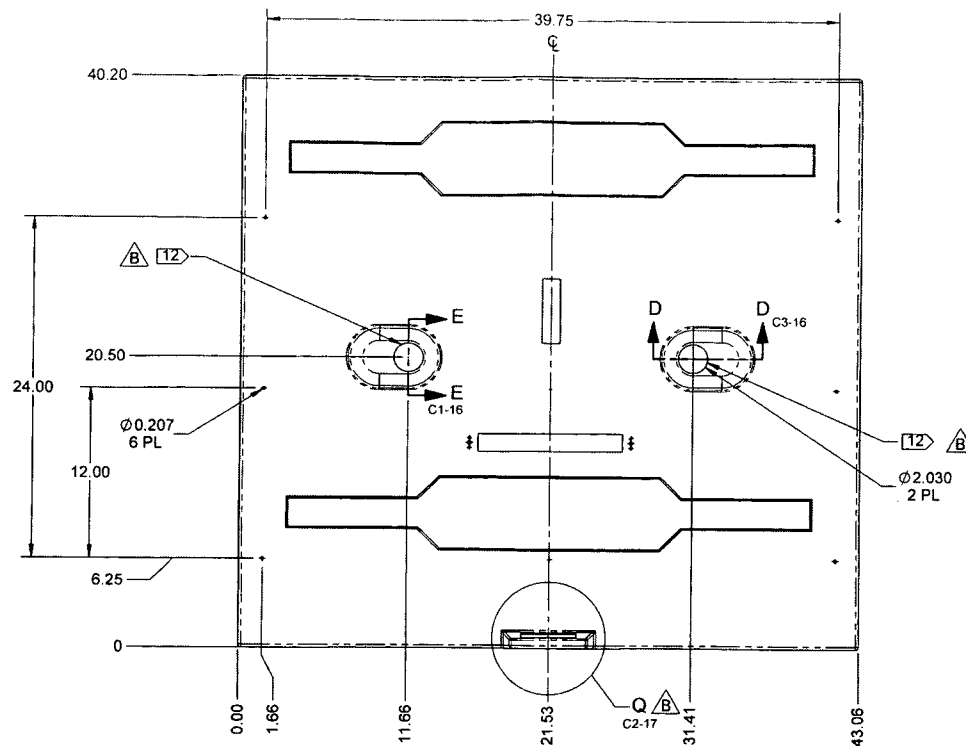
- NOTES:**
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 7.21 lbs
 - 8) TEXTURE ON THIS SIDE
 - 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
 - 10) DRILL & TRIM D4634-5 PER TOOL DT9838
 - 11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
 - 12) LOCATE $\varnothing 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

RELEASED
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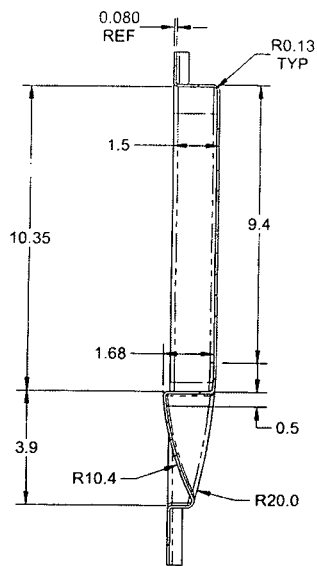


D4634-5 AFT. CENTER CEILING PANEL
AUXILIARY VIEW

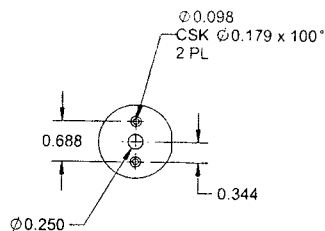
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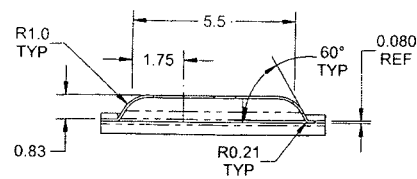
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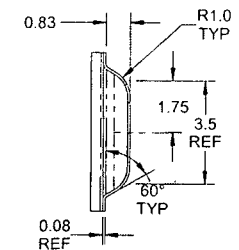
SECTION G-G C5-11
SCALE 4X



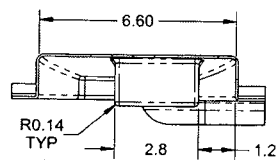
DETAIL C B7-10
SCALE 4X B4-12
B4-14



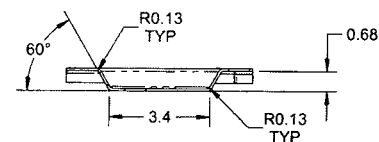
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SCALE 2X C4-13
C4-15



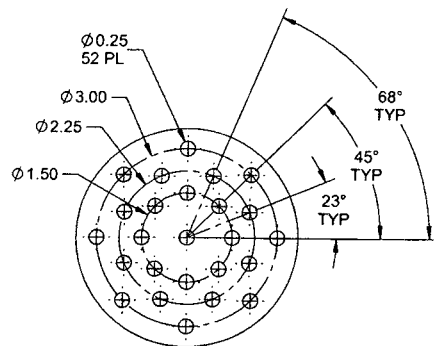
SECTION E-E B5-11
SCALE 4X C4-13
C5-15



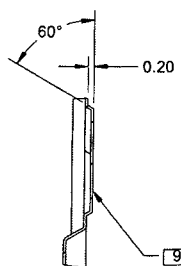
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL

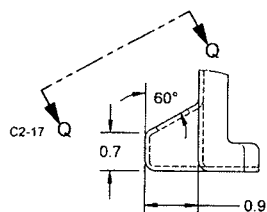


DETAIL I B2-13
SCALE 4X C2-13
TYP B2-14
C2-14

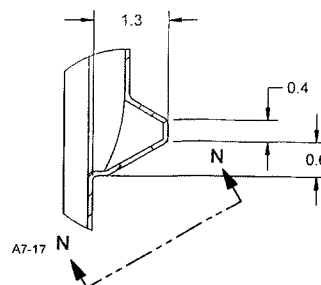
2013-01-30

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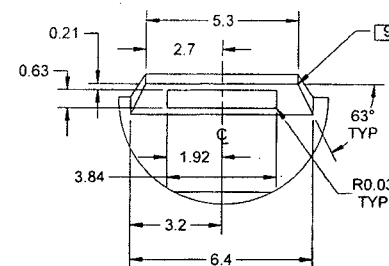
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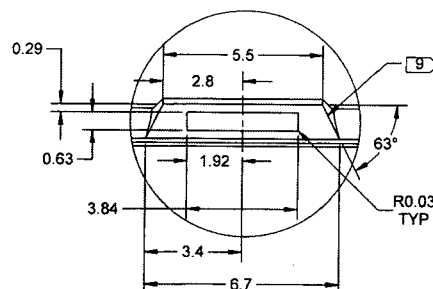
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SCALE 2X



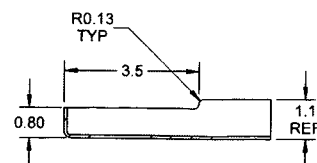
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SCALE 2X



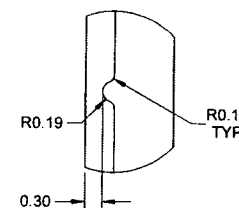
DETAIL Q B4-15
SCALE 0.5X D8-17



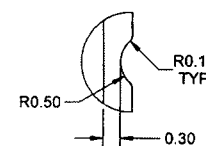
DETAIL N C5-17
SCALE 0.5X B4-15



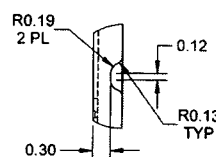
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10 B2-12



DETAIL S B3-10
SCALE 4X C2-12



DETAIL T C2-14
SCALE 4X

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DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	
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